



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2519
Job Sheet 186495



Part No: D2519

Job Qty: 50 ea

Part Name: Clamp



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/16/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP: B 00.03.16 Re-format, laser cutting EC IPP REV:C 11.10.05 MADE IN HOUSE DD
VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	50 pcs	11/30/18	11/30/18	0.00	1.71	Waterjet - Flow		<i>SL 18/11/18</i> DAS 68
120	QC	50 pcs	11/30/18	11/30/18	0.00	0.00	QC8		NOV 19 2018 68
130	Brake NC	50 pcs	11/30/18	11/30/18	0.02	2.46	Brake NC 1		<i>SL</i> DAS 68
140	QC	50 pcs	11/30/18	11/30/18	0.00	0.00	QC5		JAN 1 1 2019 68
150	Packaging	50 pcs	11/30/18	11/30/18	0.00	0.00	Packaging3	<i>57542</i>	DAS 9-89
160	QC21-SA	50 Ea	11/30/18	11/30/18	0.00	0.00	QC21		DAS 6 9-89

Part Op 100 - 1-Cut as per Dwg

Descriptions: 130 - 1- remove press and machine marking as necessary

DAS 21 9-89
JAN 14 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	2.4750 sf (.0495 ea)	100-Waterjet - Flow - 1	<i>5123198</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	2	188	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp	0.257inches + 0.006 - 0.001	0.263 0.256	<i>0.257</i>	
2	Clamp	0.400inches ± 0.030	0.430 0.370	<i>0.403</i>	
3	Clamp	0.750inches ± 0.010	0.760 0.740	<i>0.752</i>	
4	Clamp	8.561inches ± 0.010	8.571 8.551	<i>8.560</i>	
5	Clamp	0.063inches ± 0.010	0.073 0.053	<i>0.058</i>	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspect ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Threading ☐ Grinding ☐ QTY Effective ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																																					
Date : _____		Step #: _____		Container No: S128644 Part: D2519 Job No: 186495 Serial No/Batch: S128644 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 11/16/18																																																																																																																																					
Description Work Order Deviation		Description																																																																																																																																							
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%;">Environment</td><td style="width:15%;">☐</td> <td style="width:15%;">No Re-verification</td><td style="width:15%;">☐</td> <td style="width:15%;">Pressure/Force</td><td style="width:15%;">☐</td> <td style="width:15%;">Power Loss/Surge</td><td style="width:15%;">☐</td> <td style="width:15%;">Positioned Wrong</td><td style="width:15%;">☐</td> </tr> <tr> <td>Design</td><td>☐</td> <td>Operator</td><td>☐</td> <td>Bending</td><td>☐</td> <td>Program</td><td>☐</td> <td>Outside Dimensions</td><td>☐</td> </tr> <tr> <td>Doc/Data</td><td>☐</td> <td>Offset/Setup</td><td>☐</td> <td>Centre Not Concentric</td><td>☐</td> <td>Grain</td><td>☐</td> <td>Over/Under tolerance</td><td>☐</td> </tr> <tr> <td>Equip/Tooling</td><td>☐</td> <td>Supplier</td><td>☐</td> <td>Cracks</td><td>☐</td> <td>Weld</td><td>☐</td> <td>Part Incorrect</td><td>☐</td> </tr> <tr> <td>Handling/Pre</td><td>☐</td> <td>Training</td><td>☐</td> <td>Crimp/Kink/Ripple/Wave</td><td>☐</td> <td>Wrong Stock Pulled</td><td>☐</td> <td>Part Lost/Missing</td><td>☐</td> </tr> <tr> <td>Material</td><td>☐</td> <td>Use for Testing</td><td>☐</td> <td>Cuffs</td><td>☐</td> <td>Out of Sequence</td><td>☐</td> <td>Part Moved</td><td>☐</td> </tr> <tr> <td>Internal Transport</td><td>☐</td> <td>Poor Information</td><td>☐</td> <td>Crushing</td><td>☐</td> <td>Off-set</td><td>☐</td> <td>Drawing</td><td>☐</td> </tr> <tr> <td>Tribal Knowledge</td><td>☐</td> <td>Rushing</td><td>☐</td> <td>Heat Treat</td><td>☐</td> <td>Mislabeled</td><td>☐</td> <td>Finish</td><td>☐</td> </tr> <tr> <td>LOA</td><td>☐</td> <td>Product Improvement</td><td>☐</td> <td>Wave/Twist in Tube</td><td>☐</td> <td>Fit/Function</td><td>☐</td> <td>Misread</td><td>☐</td> </tr> <tr> <td>Substation</td><td>☐</td> <td>Process Improvement</td><td>☐</td> <td>Marks/Chatter</td><td>☐</td> <td>Misaligned/off center</td><td>☐</td> <td>Turning Sequence</td><td>☐</td> </tr> <tr> <td>Past Expiry Date</td><td>☐</td> <td>Manufacturing Process</td><td>☐</td> <td colspan="6" rowspan="2" style="vertical-align: top;"> OTHER : _____ _____ _____ </td> </tr> <tr> <td>Misidentified</td><td>☐</td> <td>Past Due</td><td>☐</td> </tr> </table>				Environment	☐	No Re-verification	☐	Pressure/Force	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Design	☐	Operator	☐	Bending	☐	Program	☐	Outside Dimensions	☐	Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	Grain	☐	Over/Under tolerance	☐	Equip/Tooling	☐	Supplier	☐	Cracks	☐	Weld	☐	Part Incorrect	☐	Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Material	☐	Use for Testing	☐	Cuffs	☐	Out of Sequence	☐	Part Moved	☐	Internal Transport	☐	Poor Information	☐	Crushing	☐	Off-set	☐	Drawing	☐	Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Mislabeled	☐	Finish	☐	LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Fit/Function	☐	Misread	☐	Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Misaligned/off center	☐	Turning Sequence	☐	Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____ _____ _____						Misidentified	☐	Past Due	☐	FAULT CATEGORY <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%;">BOM/Route</td><td style="width:15%;">☐</td> <td style="width:15%;">Broken/Damage/Defect</td><td style="width:15%;">☐</td> <td style="width:15%;">Inspection Incomplete/Unqualified</td><td style="width:15%;">☐</td> <td style="width:15%;">Contamination</td><td style="width:15%;">☐</td> <td style="width:15%;">Countersink</td><td style="width:15%;">☐</td> <td style="width:15%;">Cut Too Short</td><td style="width:15%;">☐</td> <td style="width:15%;">Instructions Incomplete/Unclear</td><td style="width:15%;">☐</td> <td style="width:15%;">Drill Holes</td><td style="width:15%;">☐</td> </tr> </table>				BOM/Route	☐	Broken/Damage/Defect	☐	Inspection Incomplete/Unqualified	☐	Contamination	☐	Countersink	☐	Cut Too Short	☐	Instructions Incomplete/Unclear	☐	Drill Holes	☐
Environment	☐	No Re-verification	☐	Pressure/Force	☐	Power Loss/Surge	☐	Positioned Wrong	☐																																																																																																																																
Design	☐	Operator	☐	Bending	☐	Program	☐	Outside Dimensions	☐																																																																																																																																
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	Grain	☐	Over/Under tolerance	☐																																																																																																																																
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Weld	☐	Part Incorrect	☐																																																																																																																																
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐																																																																																																																																
Material	☐	Use for Testing	☐	Cuffs	☐	Out of Sequence	☐	Part Moved	☐																																																																																																																																
Internal Transport	☐	Poor Information	☐	Crushing	☐	Off-set	☐	Drawing	☐																																																																																																																																
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Mislabeled	☐	Finish	☐																																																																																																																																
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Fit/Function	☐	Misread	☐																																																																																																																																
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Misaligned/off center	☐	Turning Sequence	☐																																																																																																																																
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____ _____ _____																																																																																																																																					
Misidentified	☐	Past Due	☐																																																																																																																																						
BOM/Route	☐	Broken/Damage/Defect	☐	Inspection Incomplete/Unqualified	☐	Contamination	☐	Countersink	☐	Cut Too Short	☐	Instructions Incomplete/Unclear	☐	Drill Holes	☐																																																																																																																										